

Work Order ID 72944

Friday, August 19, 2011 12:50:28 PM



Page 1

Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 8/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 11-08-19

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4306

C

100

Weld per dwg A/R S.S. rod Batch: 119884 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 52"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size and cut notch as per dwg D4306-4

4- Drill and chamfer holes as per dwg D4306-4 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

SAD 11-08-19

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

[Handwritten signature]

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72944

Friday, August 19, 2011 12:50:28 PM



Page 2

Item ID: D4306-044

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Item Name: Rib Assembly, RH

Start Date: 8/19/2011 Start Qty: 1.00



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Required Date: 8/31/2011 Req'd Qty: 1.00



Customer:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

5/10/22

(X)

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: B/C

0.00

P/L 11.08.22

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

11/8/22

QC

Memo

0.00

Quality Control

11/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 19, 2011 12:50:34 PM

Page 1

Work Order ID: 72944

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH



Start Date: 8/19/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	253.0000	4				
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Bushing

Location

Loc Qty

Loc Code

WA	251	
69202	51	
72316	200	
WA005	2	
66489	2	

M304TSQ.750W.049	Purchased	No			100	f	386.2431	4.166		4.385263			
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304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018	285.487909	
117690	4.372109	
117775	98.4265	
118472	182.6893	
MAT034	1.8507	
117337	1.8507	
WA	98.90454	
118184	98.90454	

4
11-08-22

4

SAD 11-08-19

4.3853

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

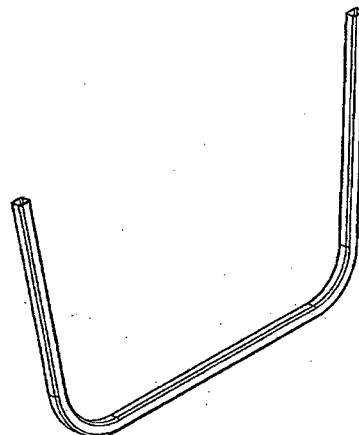
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

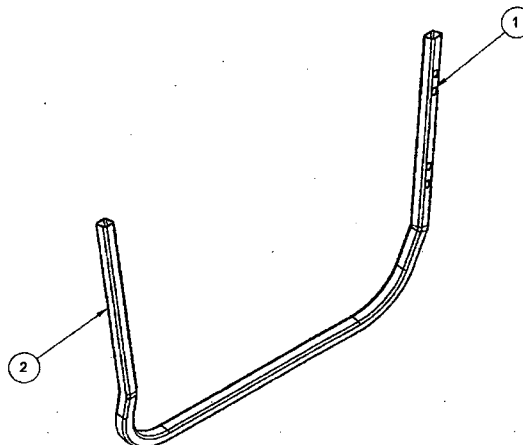
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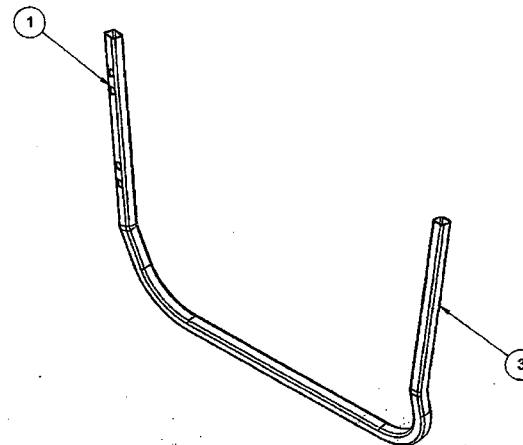
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



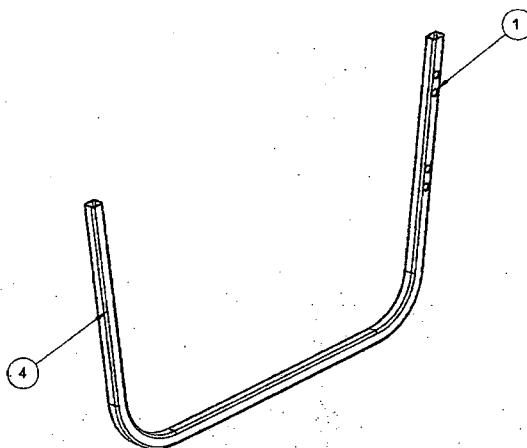
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72944
11-08-19

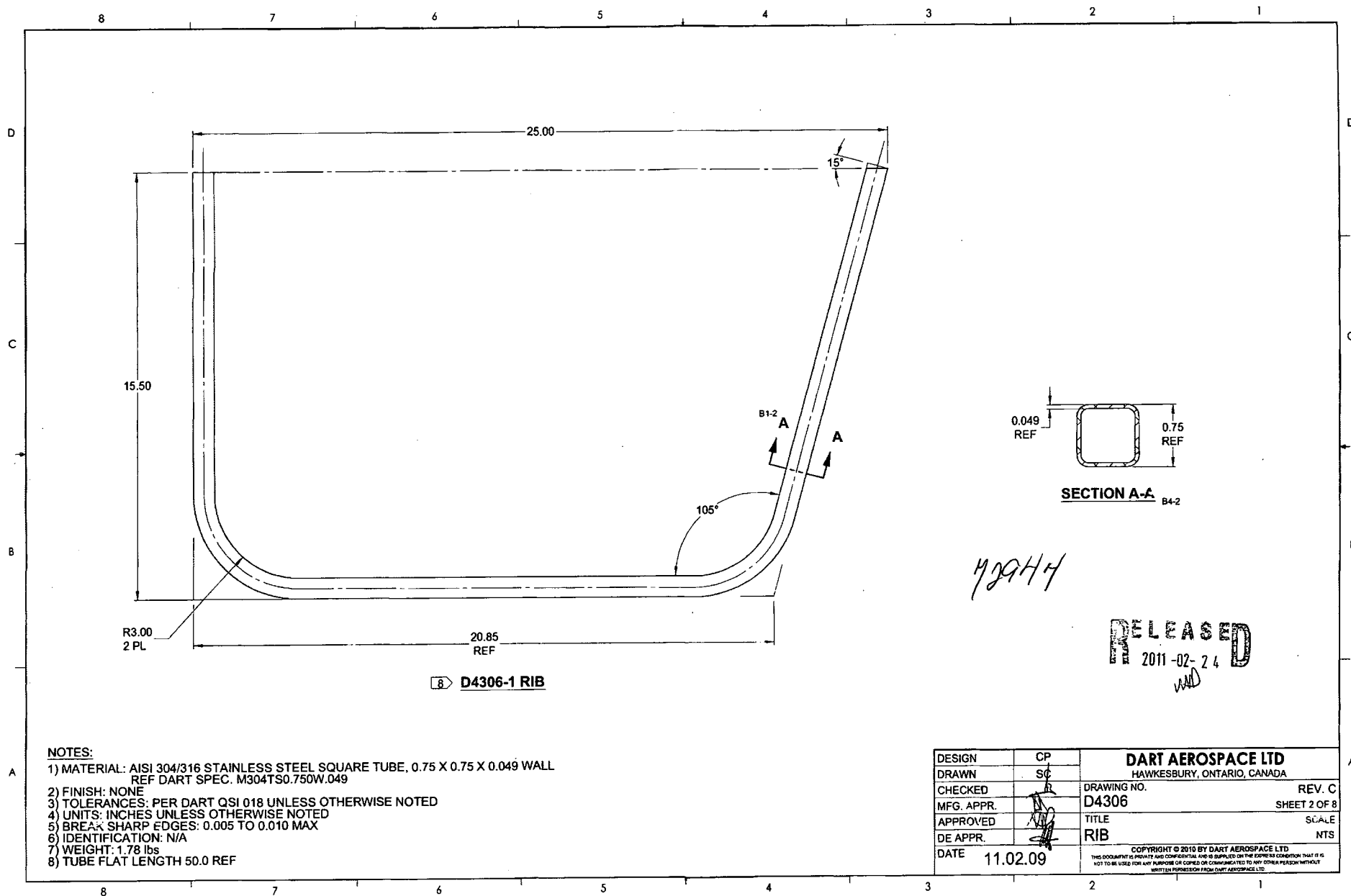
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2011-03-10

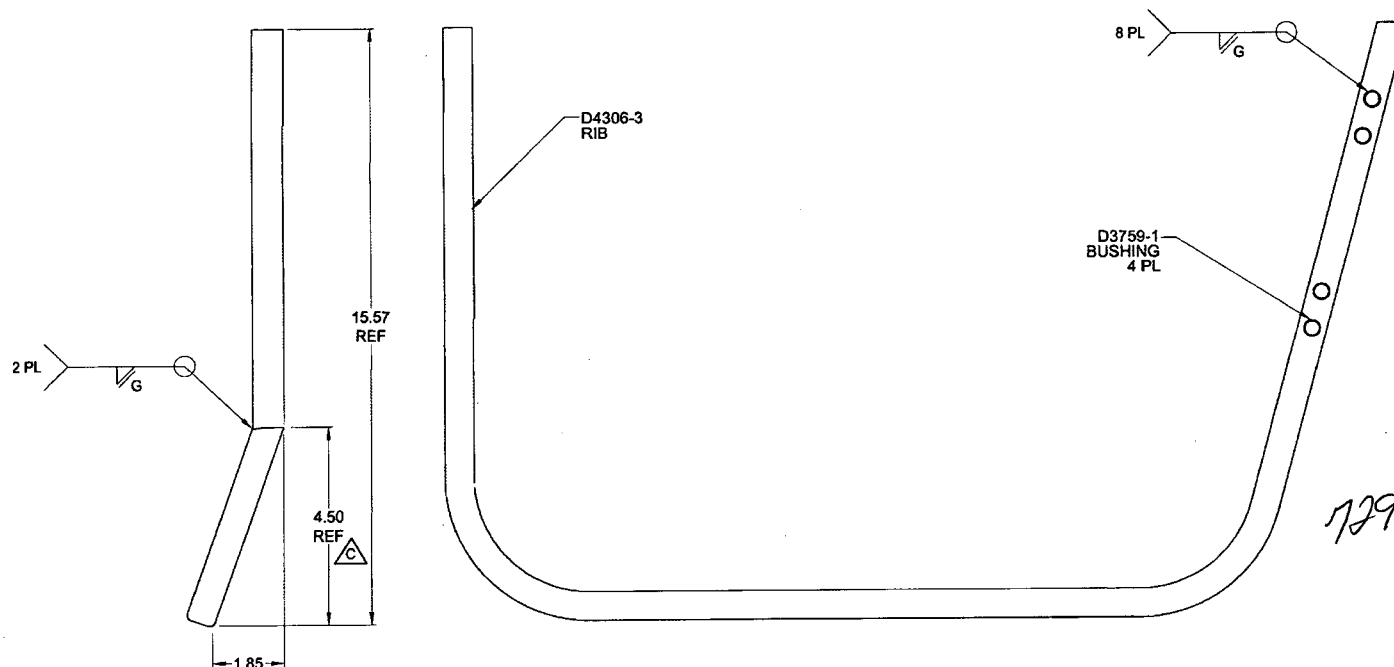
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-6)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4306** REV. C
TITLE **RIB** SCALE NTS
SHEET 1 OF 8

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D4306-043 RIB ASSY, LH

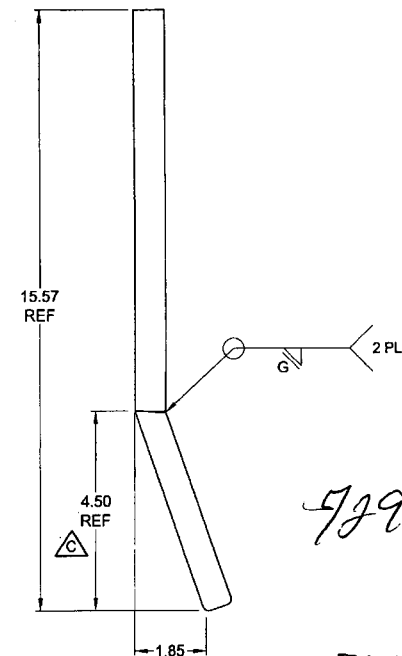
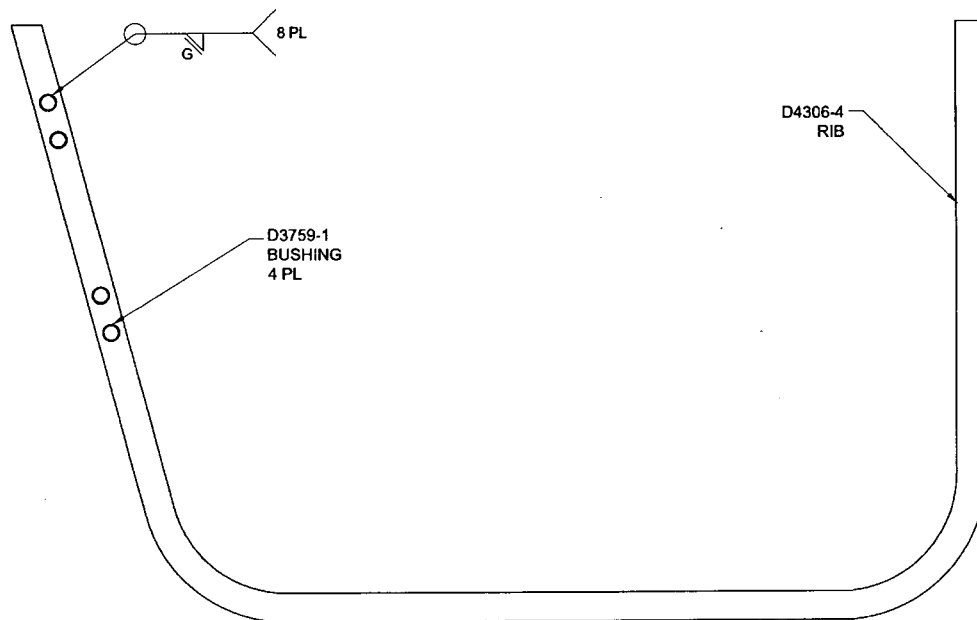
129414

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO. D4306	REV. C
MFG. APPR.			SHEET 3 OF 8
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DATE	11.02.09		



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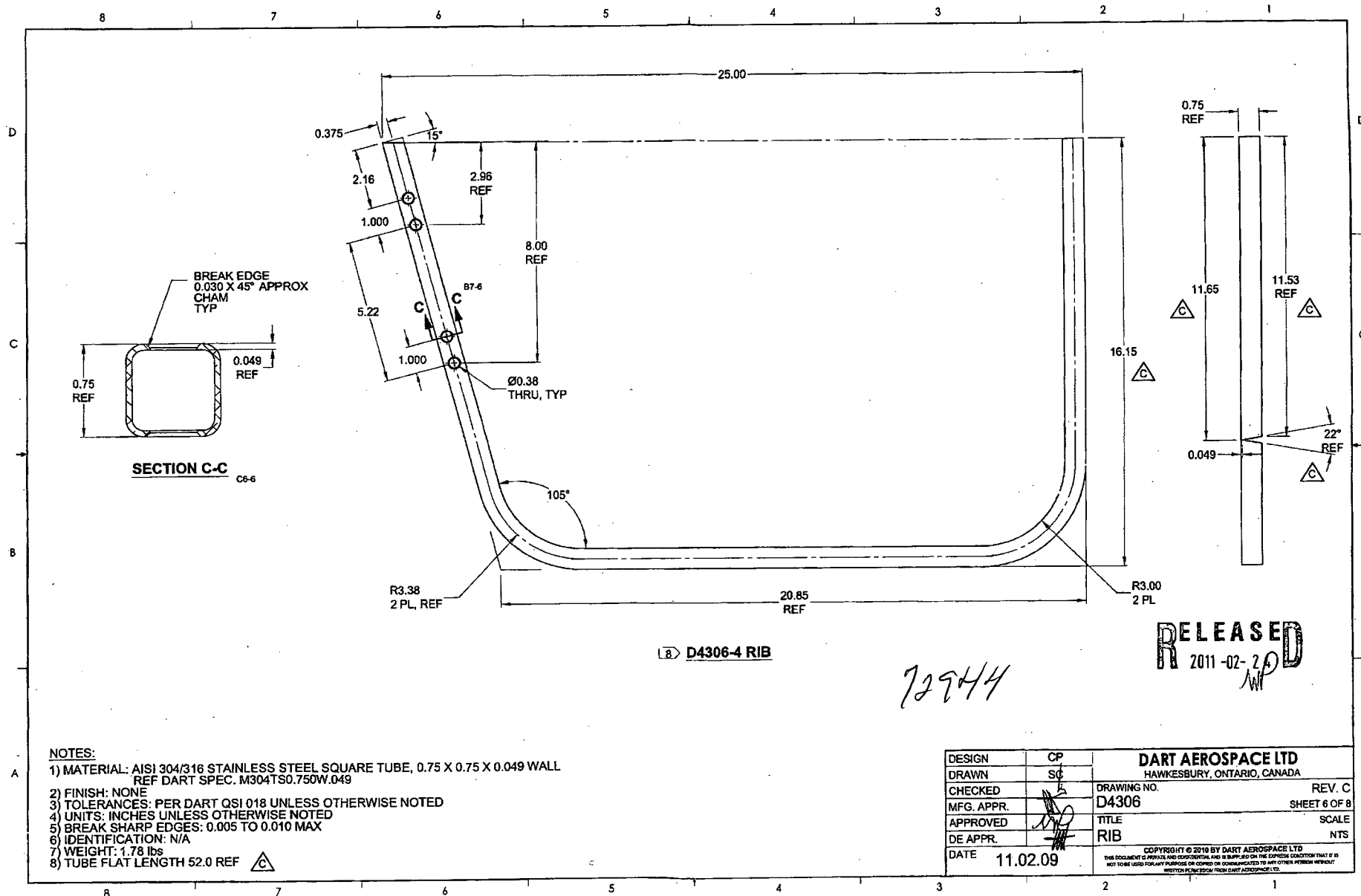
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2011-02-24
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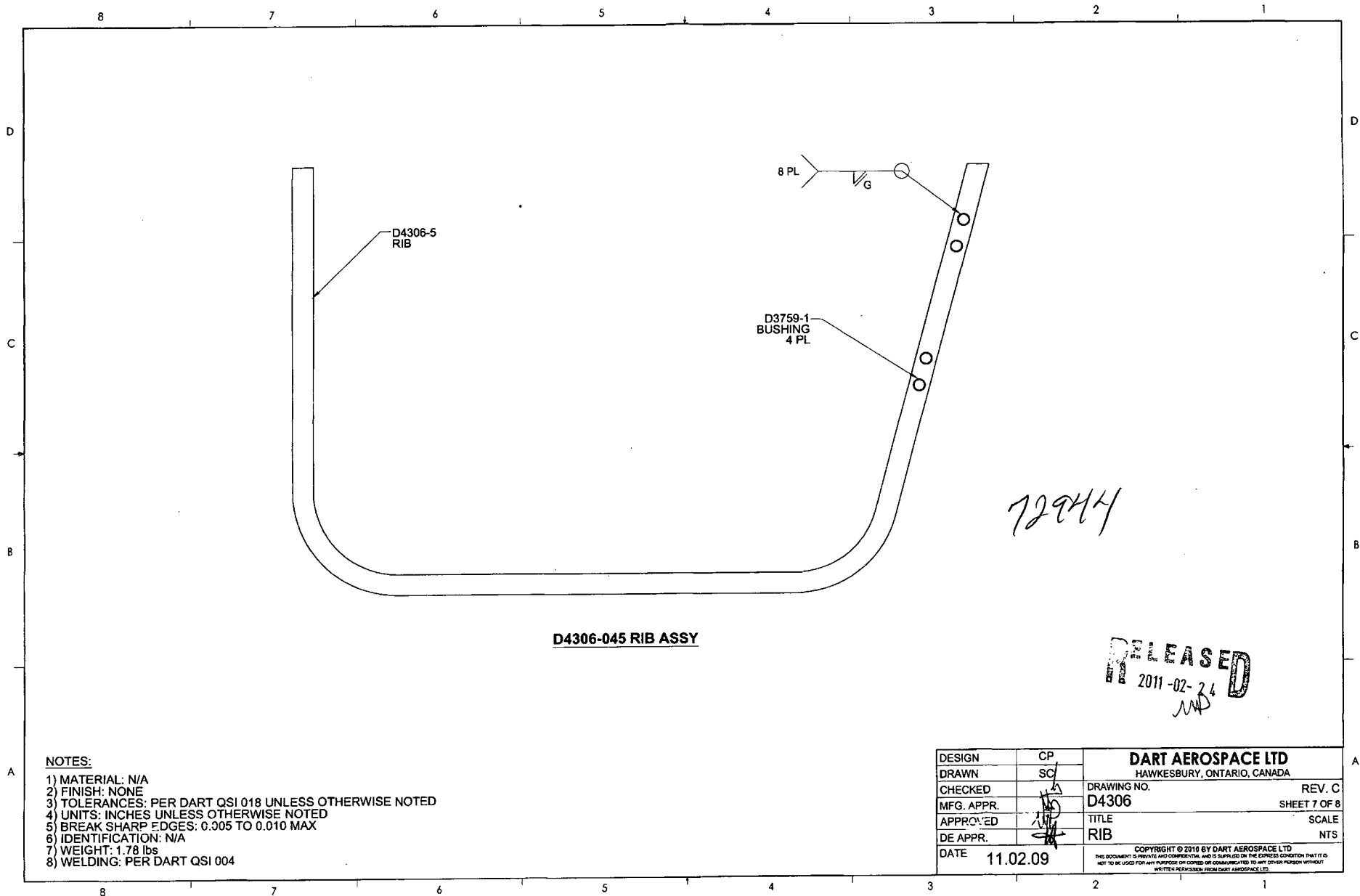
D4306-044 RIB ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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D4306-045 RIB ASSY

RELEASED
2011-02-24
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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